

Date: Wednesday, 29/10/2008 10:19:39 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD BLADE FOLD ASSEMBLY		
Job Number	: 43066					
Estimate Number	: 13531					
P.O. Number	:			Part Number	: PB674300101	
This Issue	: 29/10/2008		S.O. No. :	Drawing Number	: B6743001 P.1, 2	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: B1	
Previous Run	: 42214			Material	:	
Written By	:			Due Date	: 05/11/2008	
Checked & Approved By	: <u>MNF 08-10-20</u>			Qty:	1 Um: Each	
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB674300107	Fwd Blade Fold Assembly Weldment	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwd Blade Fold Assembly Weldment batch: <u>143063</u>	<u>MNF 08-10-04</u>
2.0	PB674300115	Fwf Adjustable Blade Support Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <u>143059</u>	<u>MNF 08-12-04</u>
3.0	PB674300111	Fwf Adjustable Blade Support Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <u>143081</u>	<u>MNF 08-12-04</u>
4.0	PB674300121	PB67-43001-21	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-21 batch: <u>141292</u>	<u>MNF 08-12-04</u>
5.0	PB674300123	PB67-43001-23	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-23 batch: <u>143057</u>	<u>MNF 08-12-04</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Longitudinal Support Assembly

batch: 41013

mf 08-11-03

7.0 PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Long T-Handle Assembly

batch: 41581

mf 08-11-03

8.0 PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever Arm

batch: 41294

mf 08-11-03

9.0 PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: 41373

mf 08-11-03

10.0 PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: 340062

wip mf 08-11-03

11.0 D3451041

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 342995

wip mf 08-12-04

12.0 D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 341355

wip mf 08-12-04

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D34473 Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Spacer

batch: 41351

MF 08-11-03

14.0 D34479 Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Swing Arm

batch: 41352

MF 08-11-03

15.0 D3445041 Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Belt Assembly

batch: B39966

MF 08-11-03

16.0 086004 Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: M109350

MF 08-11-03

17.0 MS27039104 Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: 18431

MF 08-11-03

18.0 MS27039123 SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: M18051

MF 08-11-03

19.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M109031

MF 08-11-03

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Job Number:



Seq. #:	Machine Or Operation:	Description :	
20.0	MS21042L4	Nut	
		Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s) Nut batch: m108145	MF 08-10-03
21.0	MS21042L6	Nut	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut batch: m108183	MF 08-11-03
22.0	MS518595 MS518598 64-9008	WASHER	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) WASHER batch: m106271 106271	MF 08-11-03
23.0	MS518598 MS518595 70-8008	WASHER 1 - 7	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) WASHER batch: m106421 m108486	MF 08-11-03
24.0	NAS43DD368	SPACER	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) SPACER batch: m109060	MF 08-11-03
25.0	NAS1149F0316P	WASHER	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) WASHER batch: m109031	MF 08-11-03
26.0	NAS1149F0432P	Washer	
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer batch: m18057	MF 08-11-03

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Job Number:



Seq. #: Machine Or Operation:

Description :

27.0 NAS1149F0632P WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: 18057

MF 08-11-03

28.0 NAS1149F0832P WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: M18057

MF 08-11-03

29.0 AN960JD6 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 6085

MF 08-11-03

30.0 AN410A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107178

MF 08-11-03

31.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M109285

MF 08-11-03

32.0 AN416A Bolt



AN415A M108868

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M108471

MF 08-11-03

33.0 AN611A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: M105558

MF 08-11-03

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Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN620A AN6 C16 A.

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m10583

MF 08-12-04

35.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m108986

MF 08-11-03

36.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIVET

batch: m109119

MF 08-11-03

37.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: m104214

MF 08-11-03

38.0

MS17984C408

PIN, QUICK RELEASE



m517984c-410



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m18118

MF 08-12-04

39.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m108473

MF 08-12-04

40.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

8" LANYARD

batch: m108390

MF 08-11-03

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Job Number:



Seq. #: Machine Or Operation:

Description :

41.0 30345T24 LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

LANYARDS

batch: M108973

MF 08-11-03

42.0 240107 SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850

MF 08-11-03

43.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2

242 THREADLOCK batch: M109687

SMW 08/12/04

44.0 QC5 INSPECT WORK TO CURRENT STEP



S 08/12/04 (P)

Comment: INSPECT WORK TO CURRENT STEP

45.0 PACKAGING 1 PACKAGING RESOURCE #1



(A)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: DPP

43067

811248850

46.0 QC21 FINAL INSPECTION/W/O RELEASE



08/12/04 (P)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



H2.1 Add D3447-7-x2

B 41552x1

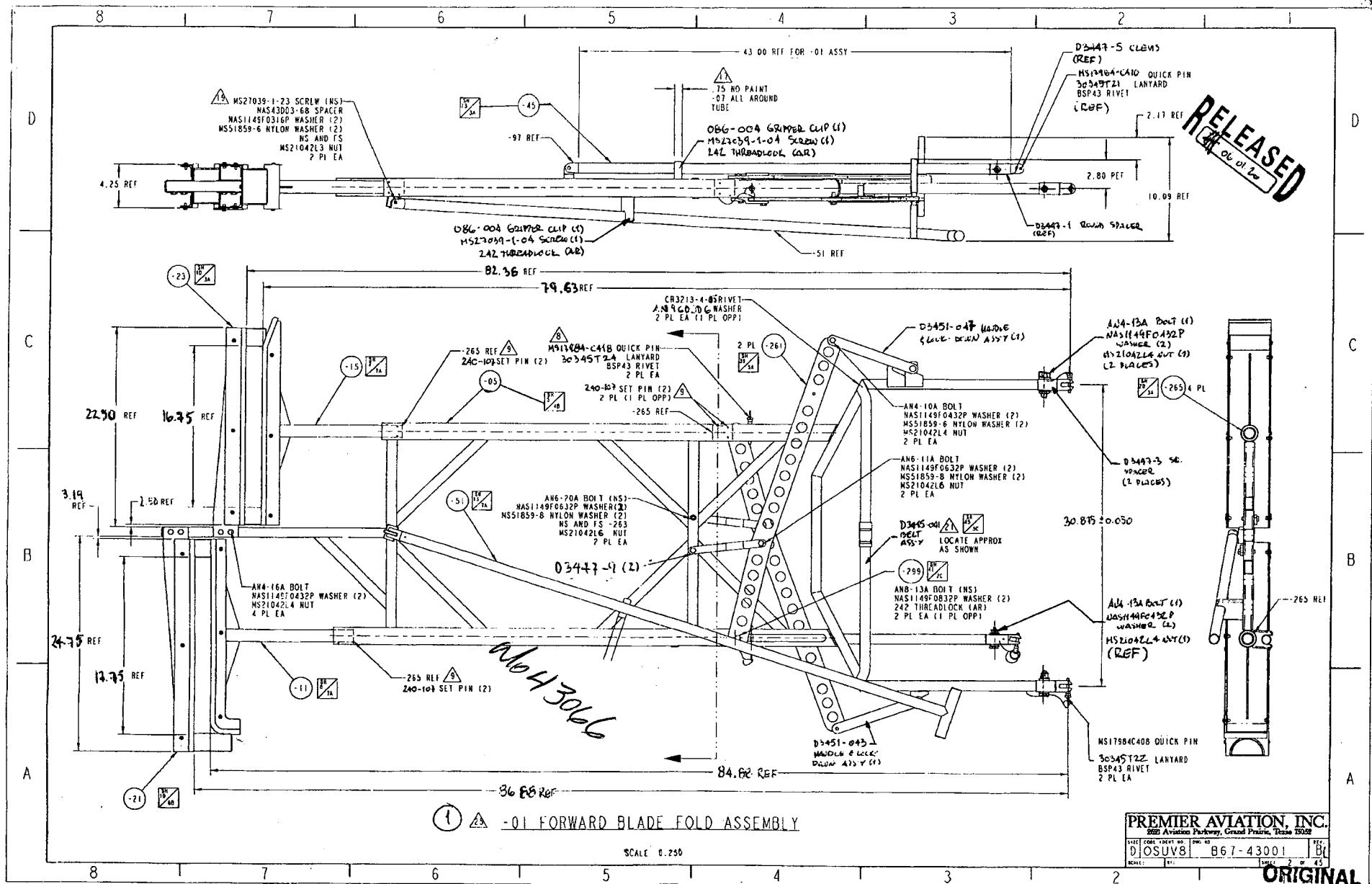
B 43895x1

MF
08-12-04

8	7	6	5	4	3	2	1	
							NOTICE: INFORMATION CONTAINED HEREIN IS PROPRIETARY TO PREMIER AVIATION, INC. AND MAY NOT BE RELEASED OR REPRODUCED WITHOUT PRIOR WRITTEN AUTHORIZATION BY PREMIER AVIATION, INC.	
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 1	2	3	4	5	6		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 7	8	9	10	11	12		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 13	14	15	16	17	18		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 19	20	21	22	23	24		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 25	26	27	28	29	30		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 31	32	33	34	35	36		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 37	38	39	40	41	42		
REV STATUS	REV B	B	B	B	B	B		
OF SHEETS	SHEET 43	44	45					
NOTES (UNLESS OTHERWISE SPECIFIED):								
<p>1. IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES I-15-12142, LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.</p> <p>2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.</p> <p>3. GENERAL SHOP PRACTICES I.A.W. PREMIER SPEC. 006-93000 AND AC43.13.</p> <p>4. OPEN</p> <p>5. WELD PARTS PER MIL-STD-2219, CLASS B.</p> <p>6. CHEM FILM (CALODINE) ALL ALUMINUM DETAILS PARTS PER PREMIER SPEC 006-93003, CLASS 1A, AND PRIME WITH EPOXY PRIMER MIL-P-23372C, ZINC CHROMATE PRIMER PER MIL-TTP-1757, OR EQUIVALENT.</p> <p>7. STITCHING PER FED-STD-751.</p> <p>8. WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (T-HANDLE LOCKED ON FOREST HOOK), DRILL A .25 DIA HOLE THROUGH THE OUTSIDE HOLES .15 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTSIDE SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY, MOVE IT TO ITS LOWEST, MOST RESESSED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE, .25 DIA.</p> <p>9. INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING IN EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT B03073 SET PIN, AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. B PL (2 PL EA BUSHING)</p> <p>10. GRIND BUSHING AND WELD TO CONTOUR OF TUBE.</p> <p>11. ALIGN CRADLE ASSEMBLY 90 DEGREES FROM THE CENTERLINE AXIS OF THE BUSHING ON THE OTHER END OF THE TUBE. WELD GUSSET ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.</p> <p>12. CHAMFER EDGE FOR BETTER WELDING.</p> <p>13. TAP HOLE TO 1/4-20 THRU.</p> <p>14. INSTALL CL-40-SBP-3 DEFENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAL SURFACE. ALIGN THE TUBE SEAL SURFACE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER STOWING.</p> <p>15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN960 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.</p> <p>16. PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED, EXCEPT WHERE NOTED, 2363U W OSHA YELLOW, PER FED-STD-525.</p> <p>17. NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE, PER PREMIER SPEC 006-93003.</p> <p>18. STITCH APPROX AS SHOWN, PER FED-STD-751.</p> <p>19. PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MSS1659 EQUIVALENT.</p> <p>20. DISENGAGE -51 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT.</p>								
SECURE -43 BELT ASSY TO TOP OF -65 (OF -.05) OR -47 (OF -.07). LOCATE APPROX AS SHOWN.								
WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137								
DRILL WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.								
SHIM AS REQD. USING NAS1149D0332J WASHERS.								
-01 FWD BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY								
-02 FWD BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY								
26. TOLERANCE ON DECIMAL .X ± .1								
27. LAST SECTION LETTER USED "L"								
DRILL NO. 30 (.05128) HOLE THRU -37 AND AND -25 (COMPONENT OF -09 ASSY). INSERT B03073 SL PIN, AND GRIND FLUSH WITH -37.								
RELEASED 06-01-20								
RELEASER								
REFERENCE ONLY								
SEE SEPARATE PARTS LIST B67-43001PL								
8 7 6 5 4 3 2 1								
REV B								
PREMIER AVIATION, INC. R60 Aviation Parkway, Grand Prairie, Texas 75052								
BLADE FOLD KIT								
D10SUUV8 B67-43001								
REF B1								

REFERENCE ONLY

SEE SEPARATE PARTS LIST B67-43001PL



EXHIBITION ONLY